

Date: Thursday, 11/23/2006 11:53:13 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
<b>Job Number</b> :	29662	<b>Part Number</b> :	D2573
<b>Estimate Number</b> :	10533	<b>Drawing Number</b> :	D2573 REV E
<b>P.O. Number</b> :	N/A	<b>Project Number</b> :	N/A
<b>This Issue</b> :	11/23/2006	<b>Drawing Revision</b> :	E
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	N/A
<b>First Issue</b> :	N/A	<b>Due Date</b> :	12/20/2006
<b>Previous Run</b> :	29512	<b>Qty:</b>	12
<b>Written By</b> :			<b>Um:</b>
<b>Checked &amp; Approved By</b> :			<b>Each</b>
<b>Comment</b> :	Est: I AS Per RevE 06-01-27 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: B25353

JML 06/12/11

12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program Batch No. 29662 Double check by: JML 06/12/09

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

JML / SD 06.12.12

12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 &amp; D2574

JML / SD 06.12.12

12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JML / SD 06.12.12

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/12/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:53:13 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 29662

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/12/14

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

am/sr

(13)

7.0

POWDER COATING

POWDER COATING



M102391



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.L / M.M 06/12/20 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M 06 12 20

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57474

06/12/21

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/22

Job Completion



06/12/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

403

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	29662
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.446	0.440	0.440	0.448		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.506	3.506	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.508	0.504	0.503	0.498		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.377	0.376	0.377	0.377		
I	0.490	0.510		0.501	0.502	0.502	0.501		
J	1.174	1.184		1.179	1.179	1.178	1.175		
K	0.558	0.578		0.567	0.568	0.567	0.566		
L	1.174	1.184		1.179	1.179	1.178	1.175		
M	1.365	1.375		1.370	1.376	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.121	4.121	4.121	4.124		
P	0.115	0.135		0.127	0.128	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.251	0.250		
S	0.115	0.135		0.134	0.132	0.129	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.246	0.240	0.240	0.240		
W	0.115	0.135		0.133	0.133	0.133	0.129		
X	0.308	0.313		0.316	0.316	0.316	0.311		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.366	0.364	0.364	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.634	0.634	0.629	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.245	0.248	0.248		
AE	1.500	1.520		1.511	1.513	1.509	1.513		
AF	0.115	0.135		0.129	0.122	0.122	0.122		
AG	0.240	0.280		0.268	0.260	0.268	0.265		
AH	0.240	0.260		0.249	0.250	0.250	0.249		
AI	2.000	2.020		2.002	2.002	2.001	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	06/12/11

Audited by:	<i>[Signature]</i>
Date:	06/12/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	29662
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1

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B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.498	.495	.498		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.501	.500	.500	.501		
J	1.174	1.184		1.179	1.172	1.179	1.179		
K	0.558	0.578		.567	.566	.568	.565		
L	1.174	1.184		1.179	1.179	1.179	1.175		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.122	4.122	4.123		
P	0.115	0.135		.127	.126	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.127	.125	.129	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.239	.240		
W	0.115	0.135		.127	.130	.129	.129		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.761	.762	.762	.762		
Z	0.352	0.372		.364	.364	.364	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.627	.628	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.25		
AE	1.500	1.520		1.512	1.512	1.512	1.512		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.248	.248	.248	.248		
AI	2.000	2.020		2.002	2.001	2.005	2.001		
AJ	0.023	0.043		.030	.030	.030	.030		
Accept/Reject									

Measured by:	SA
Date:	06.12.12

Audited by:	EA
Date:	06.12.14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>29662</b>
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<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>

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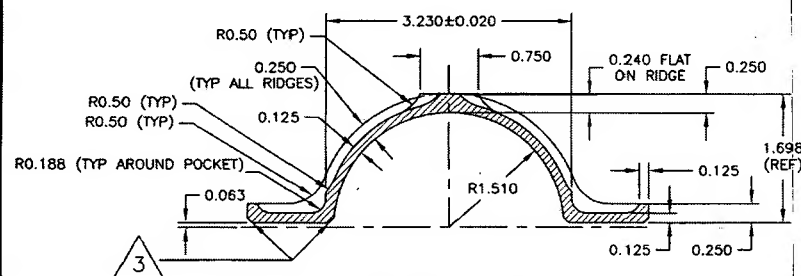
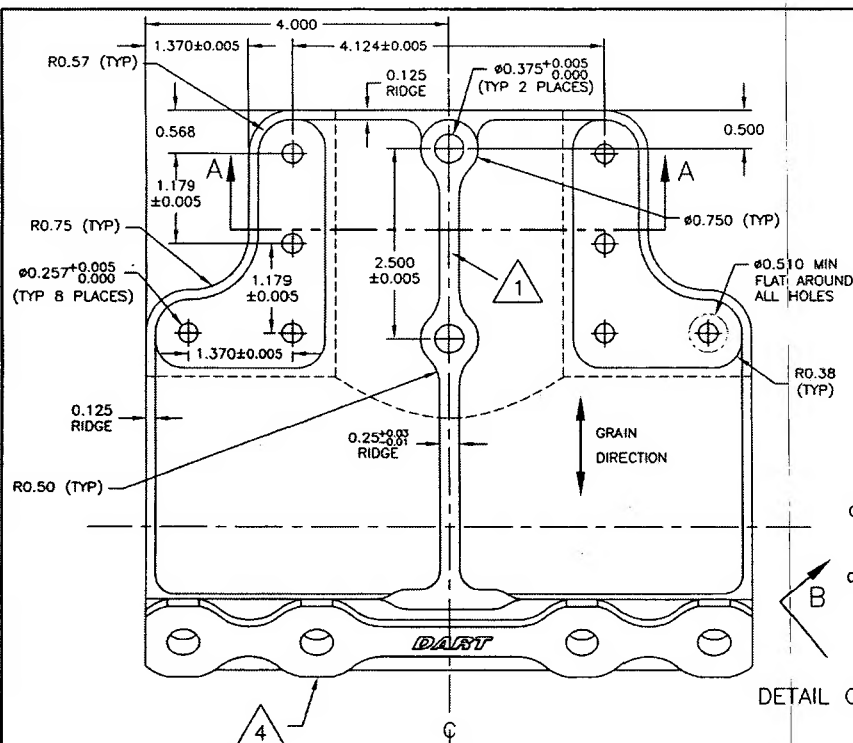
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D	1.745	1.755		1.750	1.750	1.750	1.751		
E	7.990	8.010		8.000	8.000	8.000	8.001		
F	0.490	0.510		.501	0.504	0.502	0.505		
G	0.257	0.262	DT8683	.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	.376	0.376	0.376	0.376		
I	0.490	0.510		.490	0.501	0.501	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	0.568	0.567	0.567		
L	1.174	1.184		1.175	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
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S	0.115	0.135		.126	0.132	0.132	0.129		
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U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.238	0.240	0.241	0.240		
W	0.115	0.135		.126	0.133	0.133	0.133		
X	0.308	0.313		0.311	0.311	0.310	0.310		
Y	0.760	0.765		0.762	0.760	0.760	0.760		
Z	0.352	0.372		.365	0.364	0.365	0.364		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		.627	0.628	0.629	0.625		
AC	0.053	0.073		.063	.063	0.063	0.063		
AD	0.240	0.260		.250	0.246	0.247	0.248		
AE	1.500	1.520		1.512	1.512	1.512	1.510		
AF	0.115	0.135		.135	.135	.135	0.125		
AG	0.240	0.280		.265	.265	.265	0.260		
AH	0.240	0.260		.248	0.249	0.250	0.250		
AI	2.000	2.020		2.001	2.001	2.001	2.001		
AJ	0.023	0.043		.030					
Accept/Reject									

Measured by:	SA / 9ml
Date:	06.12.13 / 06/12/14

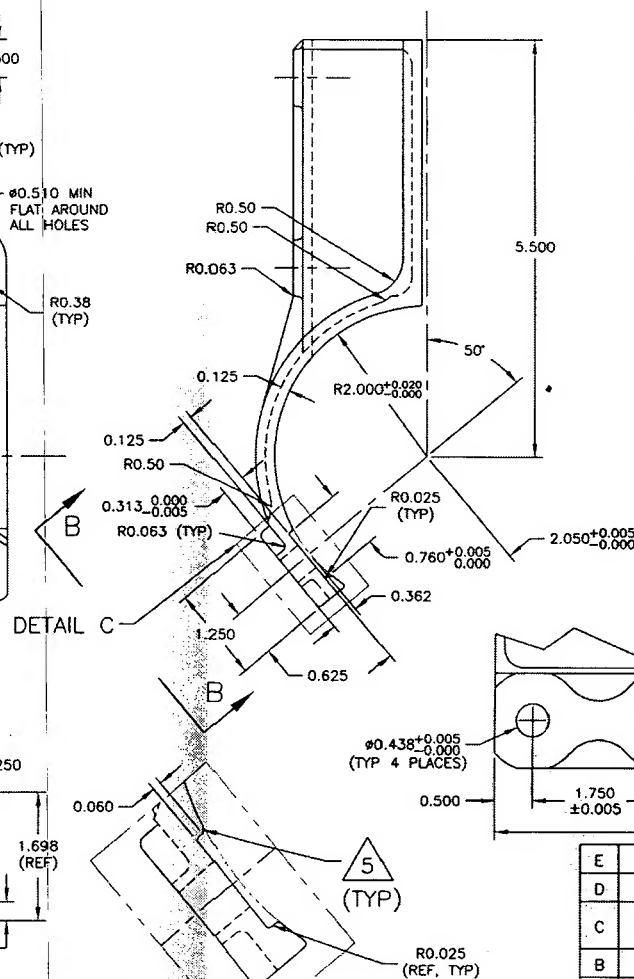
Audited by:	Gr
Date:	06/12/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06



SECTION A-A

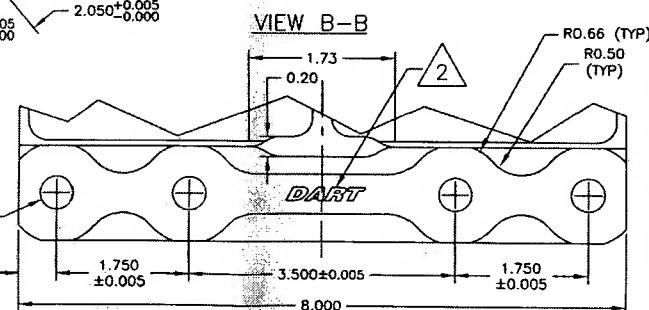





DETAIL C  
SCALE 4:3

## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN	DRAWN BY	 <b>DART AEROSPACE LTD.</b> HARRISBURY, ONTARIO, CANADA	
DS	PH		
CHECKED 	APPROVED 	DRAWING NO. D2573	REV. E
DATE 05.07.13		TITLE OUTER AFT SADDLE	SCALE

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WORK ORDER  
NO. *24602*